

Date: Friday, 12/7/2007 10:21:02 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : GUIDE
Job Number : 36188	
Estimate Number : 11216	
P.O. Number : <i>NIA</i>	Part Number : D33335
This Issue : 12/7/2007 S.O. No. : <i>NIA</i>	Drawing Number : D3333 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>NIA</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 31521	Material : <i>NIA</i>
Written By : _____	Due Date : 12/24/2007 Qty: <i>20</i> Um: Each
Checked & Approved By : <i>[Signature]</i> 07.12.07	
Comment : Est. A 05.01.13 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010B1500X01000	AISI 1010-1025 Steel Bar
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Comment: Qty.: 0.6672 f(s)/Unit Total : 5.3374 f(s)

AISI 1010-1025 Steel Bar

Material: AISI 1010-1025 or ASTM A36/A366/A569/A570 Cold Rolled Steel

(M1010-B1.500x01.000)

Identify for D3333-5

Batch: *M102210X/0RS*

→ M10622 X0 Not in system

→ 202 102248 X 7.5"

J.L / 07.12.07

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut blanks: 1.500" x 1.000" thick x 7.500" long

J.L / 07.12.07

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine as per Folio FA484 and Dwg D3333

Tap holes as per Dwg D3333

Deburr

Identify as D3333-5

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EG 07.12.07




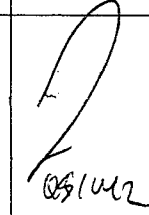
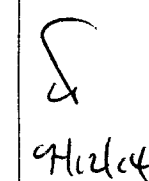
(20)

PTO →

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: DD Date: 07/12/14
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.12.14	3	806" Hole position off .100"	 05/12/14	Part was improperly clamped. Operator error. Destroy & Replace	 07.12.14	 Hedley	 05/12/14	 Hedley

NOTE: Date & initial all entries

Date: Friday, 12/7/2007 10:21:02 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GUIDE

Job Number: 36188

Part Number: D33335

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

9ml 07/12/14

(20)

6.0

POWDER COATING

POWDER COATING



M18052



(20X)

Comment: POWDER COATING

Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3
Ensure to mask threaded holes

m.h 07/12/20

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HJ



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07-12-21

(20X)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5T488*

[Signature]

AS

02/12/21

(x20)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/01/24

Job Completion



U 07.12.24

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

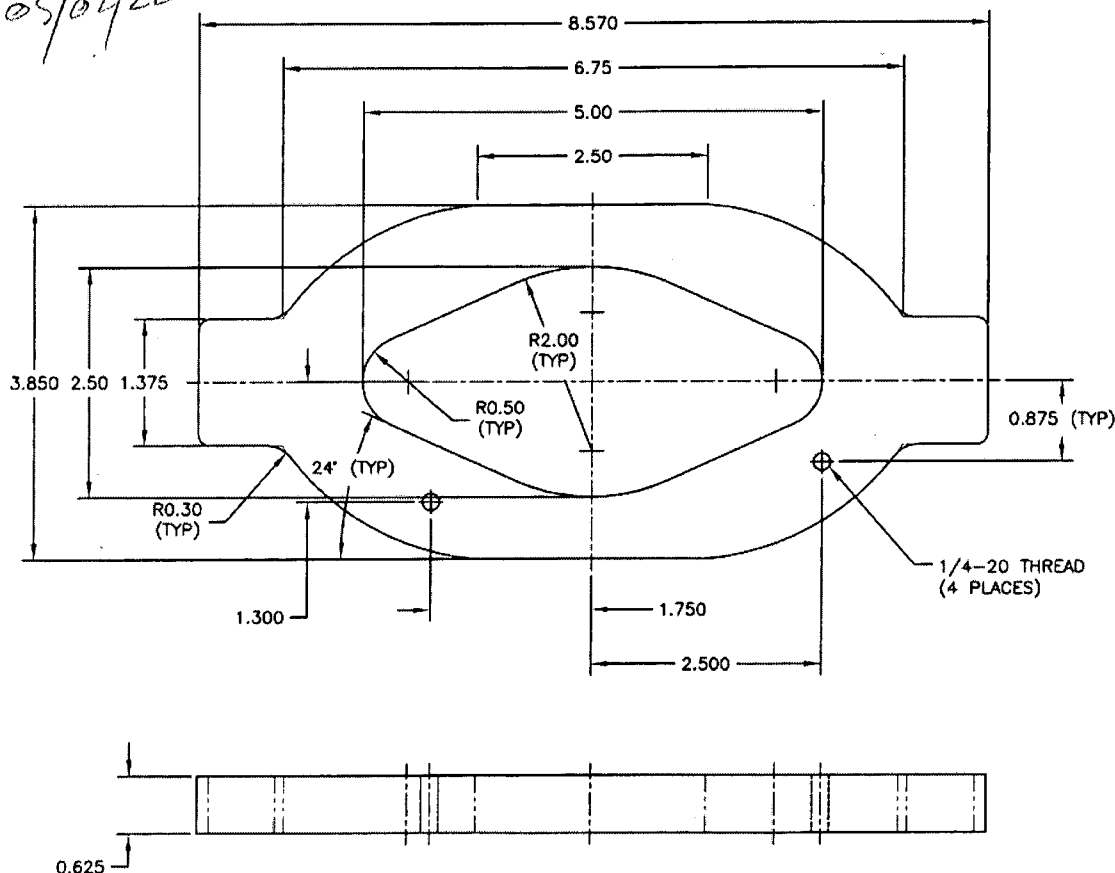
NOTE: Date & initial all entries



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CHECKED 3	APPROVED [Signature]	DRAWING NO. D3333	REV. B SHEET 1 OF 3
DATE 05.02.18	TITLE PLATE	SCALE 1:2	
A	04.12.14	NEW ISSUE	
B	05.02.18	RE-DESIGN D3333-3	

RELEASED
[Signature]

05/02/22



D3333-1 BASE PLATE PANEL

NOTES:

- 1) MATERIAL: AISI 4140 STEEL 0.625 THICK STEEL (REF. DART SPEC. M4140-B)
MIN. YIELD TENSILE STRENGTH = 100 ksi
- 2) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NO. 36188

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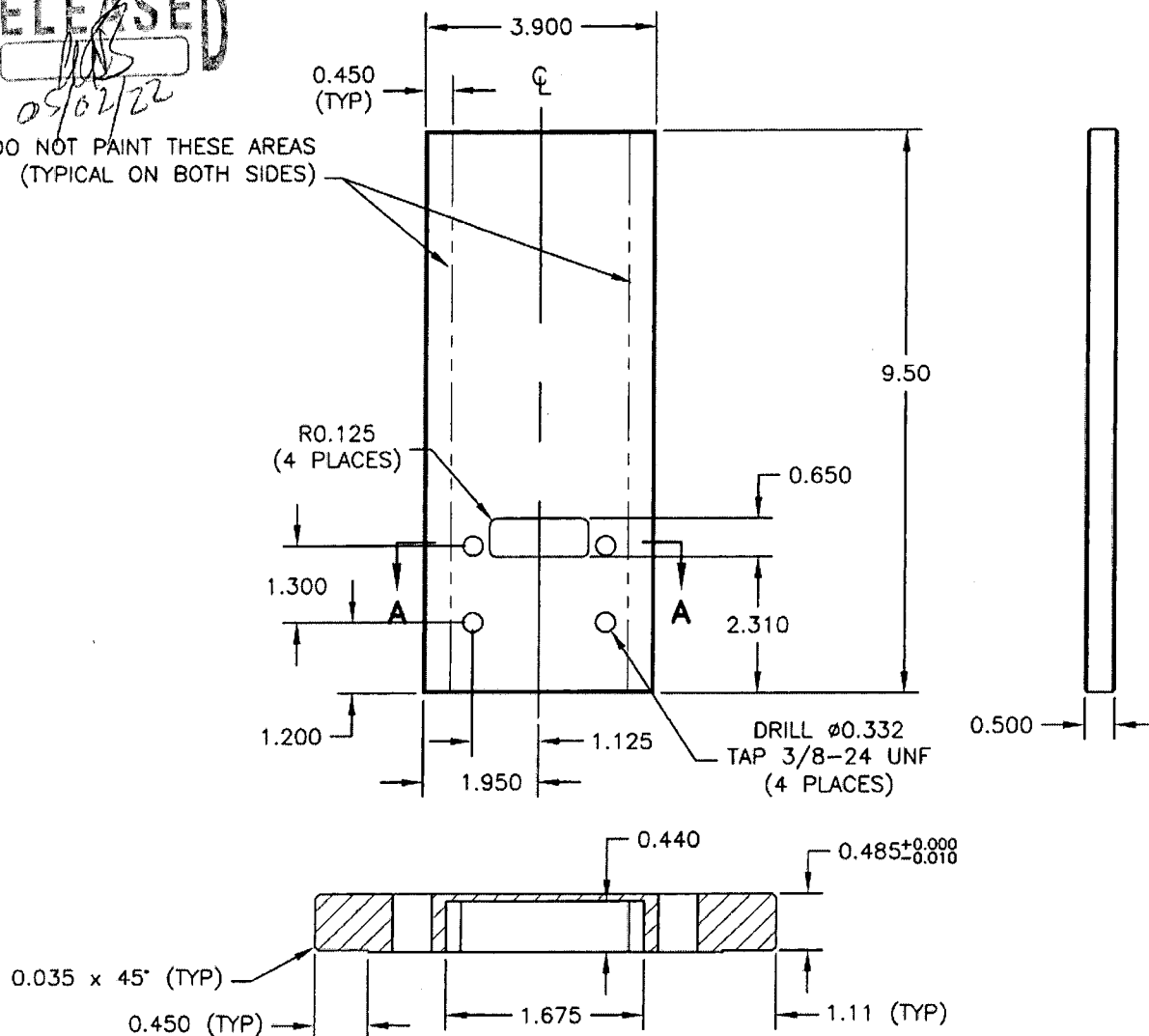
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DATE 05.02.18		TITLE PLATE	SCALE 1:4

RELEASED
05/02/22

DO NOT PAINT THESE AREAS
(TYPICAL ON BOTH SIDES)



SECTION A-A

D3333-3 SLIDING PLATE

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 0.50 THICK MILD STEEL (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

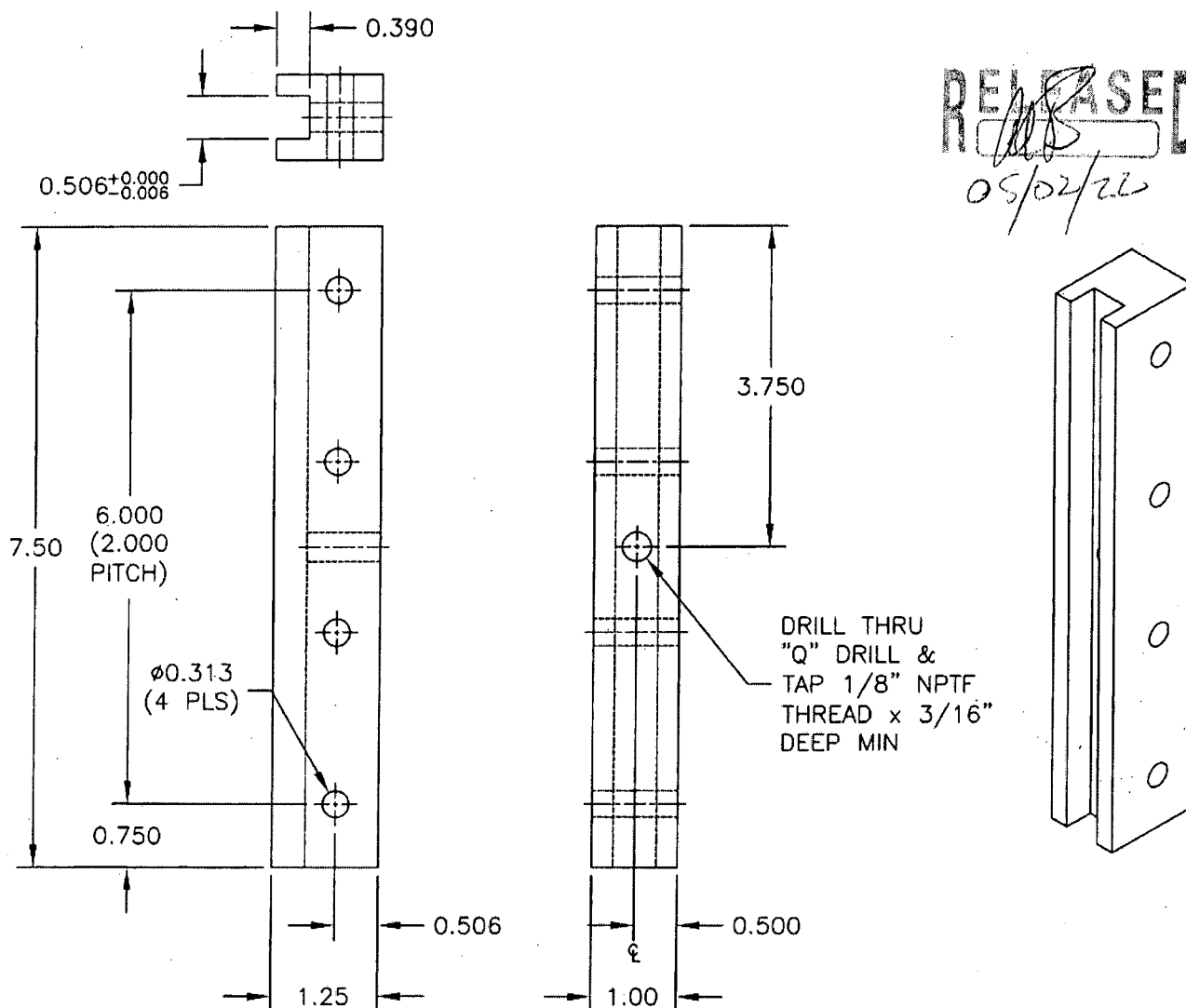
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3333	REV. B SHEET 3 OF 3
DATE 05.02.18		TITLE PLATE	SCALE 1:2



D3333-5 RAIL

NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.00 THICK (REF. DART SPEC. M1010-B)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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